

Work Order ID 70671

Monday, June 13, 2011 1:07:11 PM



Page 1

Item ID: D3442-3

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 6/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3442

Rev A Rev B

100

0.00

P/D 7



FLOW WATER JET

Waterjet

Memo

0.00

B1-6-57

FLOW CNC Waterjet

304.037

1-Cut as per Dwg D3442

 Dwg Rev: A Prog Rev: N 2-

Deburr if necessary

(B)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

B1-6-57

QC

Quality Control

120

QC8- Inspect parts - second check

0.00



Memo

0.00

S W06/07



QC

Quality Control

W/O: 70671

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE Perm. Change	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
16/02	# 100	update reason Box for correct Day Rev	B	16/02/2028	N/A	S 16/02/27	

Part No: D3442-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: WA

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

SAO

11-06-27

(15)

n/6/28/J

11-06-28
(15)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:07:17 PM

Page 1
1

Work Order ID: 70671



Parent Item: D3442-3



Parent Item Name: Shim

Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.09.02 New issue KJ/JLM
IPP B 07.07.23 waterjet EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	56.5600	0.025	0.105263			

304/316 .032 Sheet

Location	Loc Qty.	Loc Code
020	7	
109057	7	<u>109057</u>
MAT020	49.56	
117379	49.56	

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	70671
Description: Shim	Part Number:	D3442-3
Inspection Dwg: D3442	Rev. A	Rev. B

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>11-6-07</u>	Date: <u>11/06/07</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

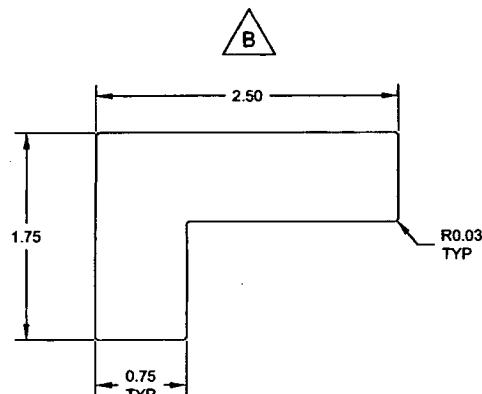
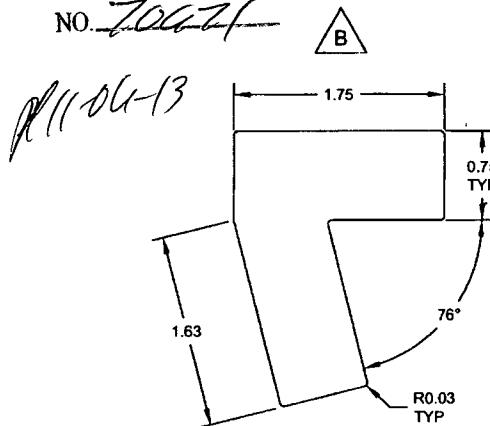
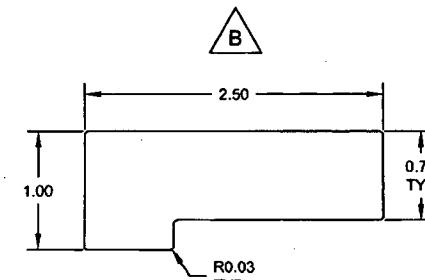
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

SHOP COI^{5Y}

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70621

D3442-1 SHIMD3442-3 SHIMD3442-5 SHIM

RELEASED
2011-05-30
WJ

NOTES:

- 1) MATERIAL D3442-1-3: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
22 GAUGE (0.031 THICK)
REF. DART SPEC. M304S22GA
- D3442-5: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
16 GAUGE (0.063 THICK)
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs APPROX



B	REFORMAT. MATERIAL FOR -1 & -3 WAS 21 GAUGE. TOLERANCE UPDATED FOR ALL PARTS. (SEE PAR 10-005)	AJS	11.05.26
A	NEW ISSUE	PH	05.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>EZ</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EZ</i>	D3442	SHEET 1 OF 1
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	SHIM	NTS
DATE	11.05.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

6

5

4

3

2

1

A

D

C

B

W/O:		WORK ORDER CHANGES					
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